

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029933**Date Inspected:** 09-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** Metalset Inc.,**Location:** Richmond, CA**CWI Name:** Dave Alvarez (QCC)**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hood Assemblies**Summary of Items Observed:**

Summary of Items Observed: Caltrans Quality Assurance Inspector Simion Ramirez (QA Inspector) arrived at Metalset Inc., facility in response to an Inspection Request (Caltrans form TL-38). QA Inspector met with Quality Control Contact (QCC) noted above to witness fabrication and welding of Hood Assemblies. Production work was selected randomly by QA Inspector for QA Visual Testing (VT). Inspections performed were in accordance (IAW) with Section 75 Miscellaneous Metal of the Standard Specifications and the project Special Provisions.

Hood Assemblies:

Metalset personnel fit-up and started welding fillet weld joints for piece marks P1, P3, P4 and P6. Prequalified welding procedure was available for the welder to reference. QC Inspector verified fit-up. Weld passes were cleaned by chipping and wire brush. The welding of piece remains in process.

- A square straight edge was utilized to check fit-up and alignment of assembled components.
- Welding was performed by certified welder (Cesar Ruiz).
- Weld Procedure (Fillet Weld E71T-CO) is pre-qualified for fillet weld T-Joints.
- Electrode utilized was E71T-1C-JH16, diameter .045".

Fabrication and welding remains in progress.

Summary of Conversations:

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Ramirez,Simion

Quality Assurance Inspector

Reviewed By: Foerder,Mike

QA Reviewer